

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D058-676 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D058-676 REV. 0
REF: FAA STC: SR01018SE

For D058-676-101/-201 crosstubes at CHG 002 or later, the D2856-400-694 abrasion strips have been removed, the D2891-1 supports have been bonded onto the crosstube using Magnabond 6398 and D3595-063-395 Rubber Cushions have been installed underneath the MS21920-20 Clamps. Amend parts list of the IIN-D058-676 Section 5 and ICA-D058-676 Section 32.8 as follows:

REMOVE:

ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
11	2	2	D2856-400-694	ABRASION STRIP

ADD:

ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
16	4	4	D3595-063-395	RUBBER CUSHION

To prevent the supports from shifting on the D058-676-101/-201 crosstubes at CHG 001, the D2891-1 supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D058-676 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty (2) MS21920-20 clamps from the crosstube that fasten each D2891-1 support to the crosstube.
- 3) Remove the D2856-400-694 abrasion strips from the crosstube per section 32.5 of ICA-D058-676.
- 4) Inspect the crosstube surface underneath each support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D058-676. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D058-676. Touch up finish per item 5.3.9 of the 300 hour inspection.
- 5) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe are until there is no residue.
- 6) Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath each D2891-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1 supports on the crosstube using MS21920-20 Clamps. Install a D3595-063-395 Rubber cushion underneath each MS21920-20 Clamp. Torque clamps 80-100 in-lb. Let the D058-676-101/-201 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

A	NEW ISSUE		RF	08.11.06
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	PORT HADLOCK, WA		
CHECKED	DS	DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9425	SHEET 1 OF 2	
APPROVED	DS	TITLE	SCALE	
DE APPR.	<i>MM</i>	CROSSTUBE SUPPORT CHANGE	NTS	
DATE	08.11.06	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

7) Re-install the D058-676-101/-201 crosstube per section 32.2 of ICA-D058-676.

For customers who would like to upgrade their D058-676-101/-201 crosstubes from CHG 001 or earlier to CHG 002, the following kit can be obtained from Dart:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9425-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D058-676-101/-201)
4	D3595-063-395	RUBBER CUSHION

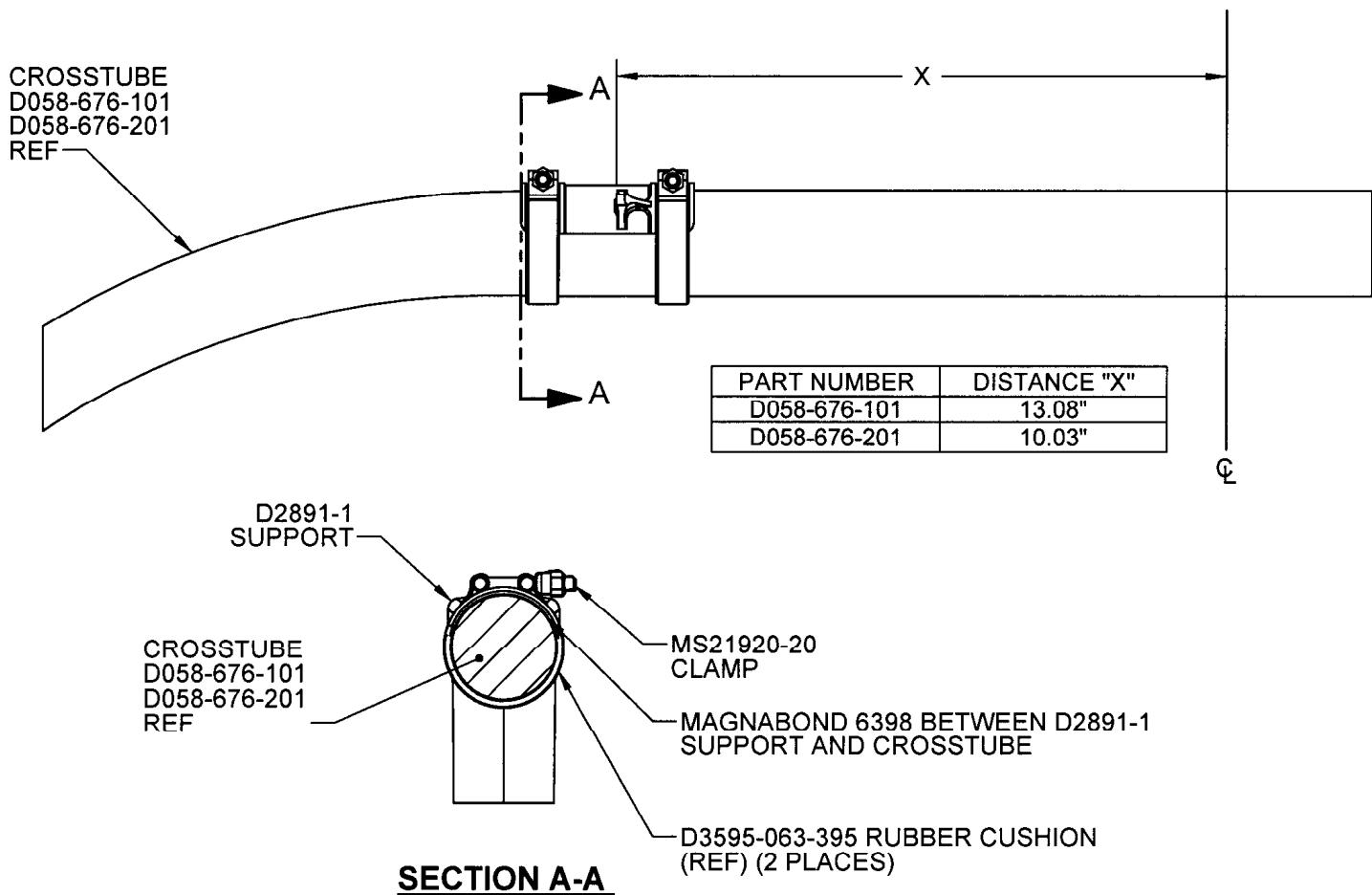


FIGURE 1 - CROSSTUBE SUPPORT

DESIGN DRAWN	RF RF	DART AEROSPACE USA, INC.	
CHECKED	DS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9425	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	
DATE	08.11.06	NTS	

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.